

Work Order ID 86941

July-09-12 2:53:58 PM

86941

Page 1

Item ID: D2506 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Label Plate
 Start Date: 7/09/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2506 | Rev F | | | | | | | | |

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2506 Dwg Rev: F Prog Rev: F 2-
 364.040 Debur if necessary
10 0 Jm 12-7-17

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
10 0 Jm 12-7-17

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control
 (DAS 16 9-89) 12/4/17
 (Signature)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Work Order ID 86941***86941***

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July-09-12 2:53:58 PM

Item ID: D2506

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Label Plate

Start Date: 7/09/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/7/2348

mf
12-07-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Dart Aerospace Ltd

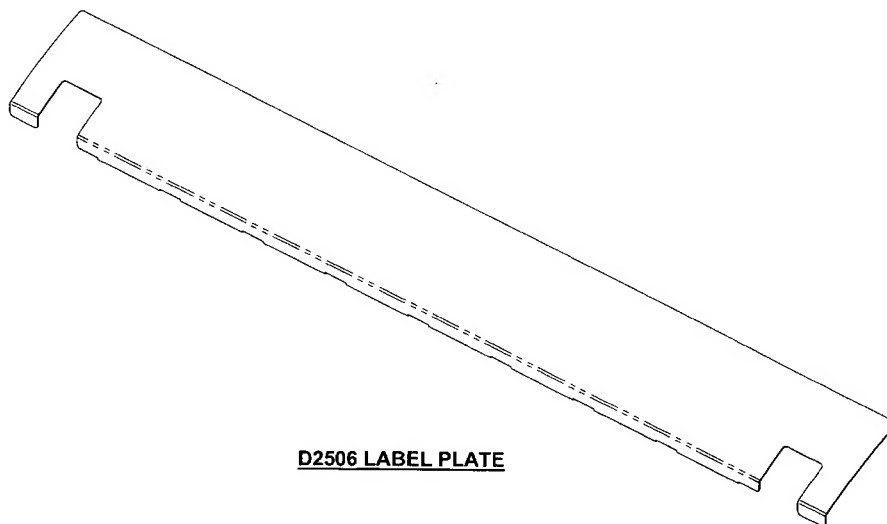
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NOTE: Date & initial all entries



D2506 LABEL PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

86941 MLJ
12/07/10

RELEASE
08/07/18 MB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

| | | | |
|------------|---|---|--------------|
| F | REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124"±1" WAS 127" (ZN A4-2). REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS | MB | 08.09.23 |
| E | REMOVE 10" BEND; ADD NOTES; 127" WAS 126" | CB | 06.11.20 |
| D | 32.63 WAS 32.25; 1.31 WAS 1.50 | KE | 99.10.04 |
| C | RE-DESIGN OF LABEL PLATE | MM | 96.09.04 |
| B | RE-DESIGN OF LABEL PLATE | MM | 96.06.18 |
| A | NEW ISSUE | KH | 95.11.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JS | | |
| CHECKED | JS | DRAWING NO. | REV. F |
| MFG. APPR. | JS | D2506 | SHEET 1 OF 2 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | LABEL PLATE | NTS |
| DATE | 08.09.23 | <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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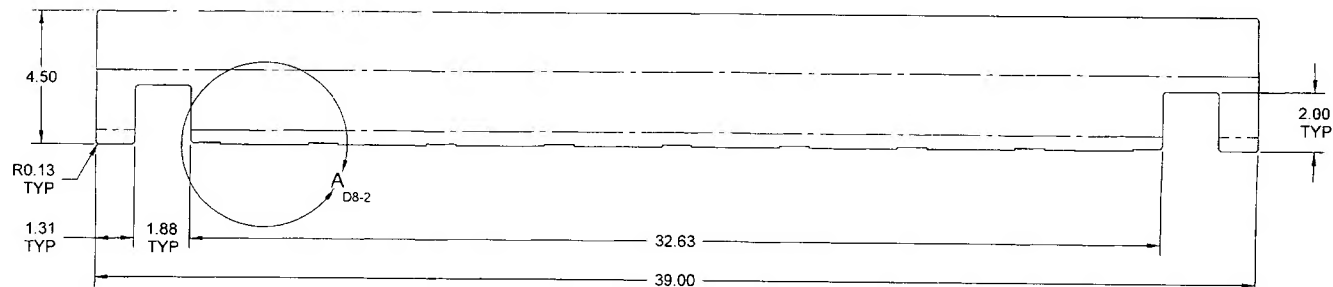
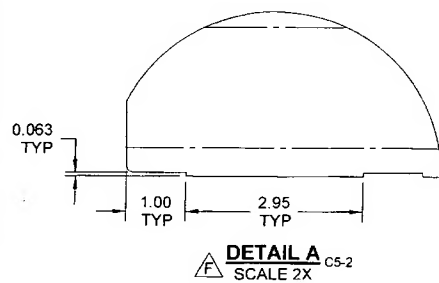
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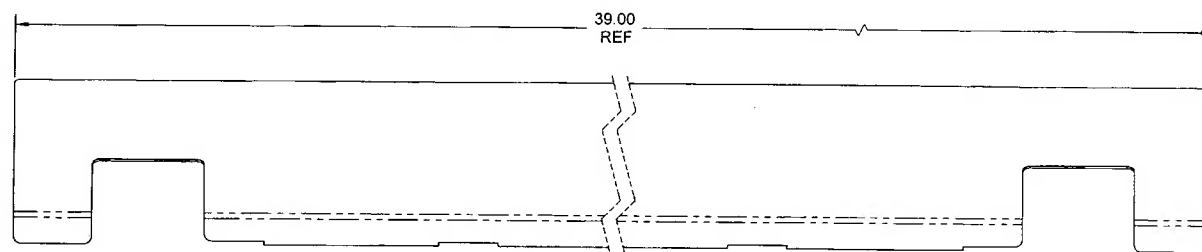
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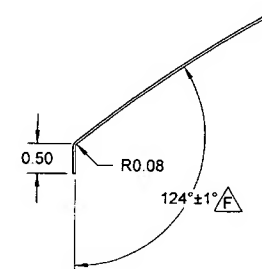
86941



D2506-F LABEL PLATE
(FLAT PATTERN)



D2506 LABEL PLATE
(MAKE FROM D2506-F)



RELEASED

| | | | |
|------------|----------|--|--------|
| DESIGN | BIV | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JLS | DRAWING NO. D2506 | REV. F |
| MFG. APPR. | | SHEET 2 OF 2 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LABEL PLATE | NTS |
| DATE | 08.09.23 | COPYRIGHT © 1995 BY DART AEROSPACE LTD | |
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